

Work Order ID 61707

Tuesday, August 31, 2010 1:46:44 PM



Page 1

Item ID: D3536-25

Accept



Setup Start



Revision ID:

Stop



Item Name: Gasket

Start Date: 8/31/2010 Start Qty: 16.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 16.00

Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

10-8-31

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3536	Rev A								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3536 ☒ Dwg Rev: *A* ☐ Prog Rev: *A* ☐ 2-
Deburr if necessary

B 10-9-1

(26)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 10-9-1

120

QC8- Inspect parts - second check

0.00



QC

Memo *34-03*

0.00

Quality Control

A1272

26

1005-2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Tuesday, August 31, 2010 1:46:44 PM



Page 2

Item ID: D3536-25

Accept



Setup Start



Revision ID:

Stop



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Start Date: 8/31/2010 Start Qty: 16.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Identify as per dwg & Stock Location: EP-12 0.00

Memo

0.00

BR 10-9-7 (26)

Packaging

140



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

10/09/07
MF
10-9-07

Dart Aerospace Ltd

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NOTE: Date & initial all entries

Picklist Print

Tuesday, August 31, 2010 1:46:48 PM

Page 1

Work Order ID: 61707

Parent Item: D3536-25

Parent Item Name: Gasket





Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063  NEOPRENE SHEET 0.063		Purchased	No			100	sf	611.2133	0.5956	10.03116	15.5		
											13 10-9-1		

Location

Loc Qty

Loc Code

MAT

505.9602

114691

105.9602

115500

400

115500

MAT052

105.2531

114176

105.2531



Dart Aerospace Ltd

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	61707
Description: Gasket		Part Number:	D3536-25
Inspection Dwg: D3536 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
21.80	+/-0.030	21.80	x		T #301	
16.35	+/-0.030	16.35	✓		T	
10.90	+/-0.030	10.90	x		T	
5.45	+/-0.030	5.45	x		T	
6.00	+/-0.030	6.00	≥		T	
6.75	+/-0.030	6.75	≥		T	
12.75	+/-0.030	12.75	≥		T	
1.89	+/-0.030	1.888	≥		T	
0.30	+/-0.030	.301	x		V #302	
0.30	+/-0.030	.298	≥		V	
Ø0.19	+0.005/-0.001	.190	x		V	

Measured by: B	Audited by: [Signature]	Prototype Approval:	N/A
Date: 10-9-1	Date: 1005-02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM [Signature]	[Signature]

W/O:		WORK ORDER CHANGES					
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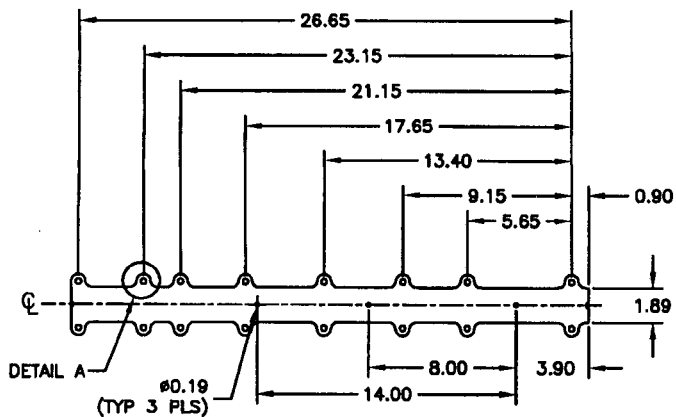
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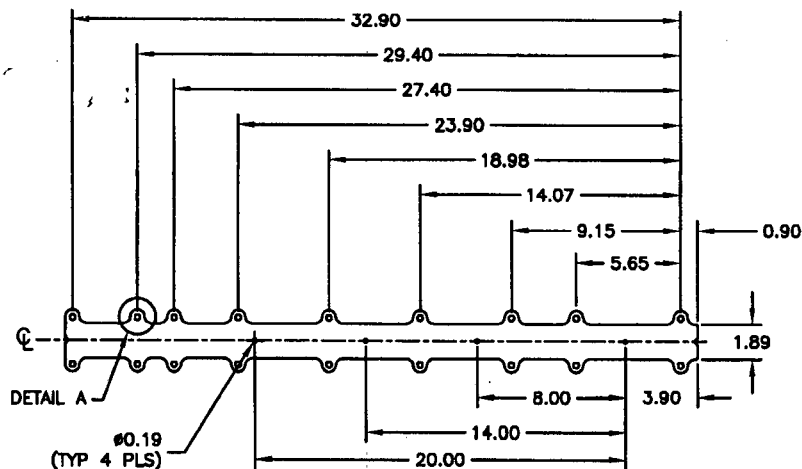
09.02.12-11

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 61707

810-8-31



D3536-11 GASKET



D3536-13 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CB	CB	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. A
PH	PH	D3536	SHEET 1 OF 6
DATE	TITLE	SCALE	
06.10.25	GASKET	1:10	
A	06.10.25	NEW ISSUE	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

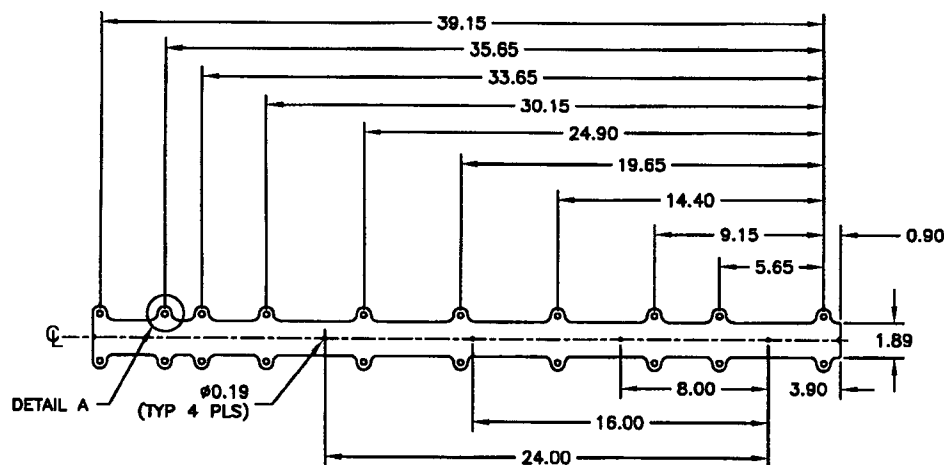
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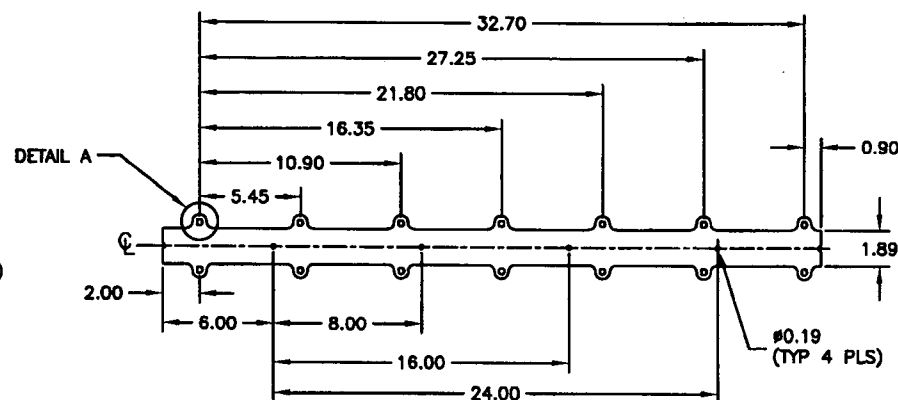
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DATE	06.10.25	TITLE	D3536	REV. A
		GASKET		SHEET 2 OF 6
				SCALE
				1:10

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w/061707



D3536-15 GASKET



D3536-21 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE080-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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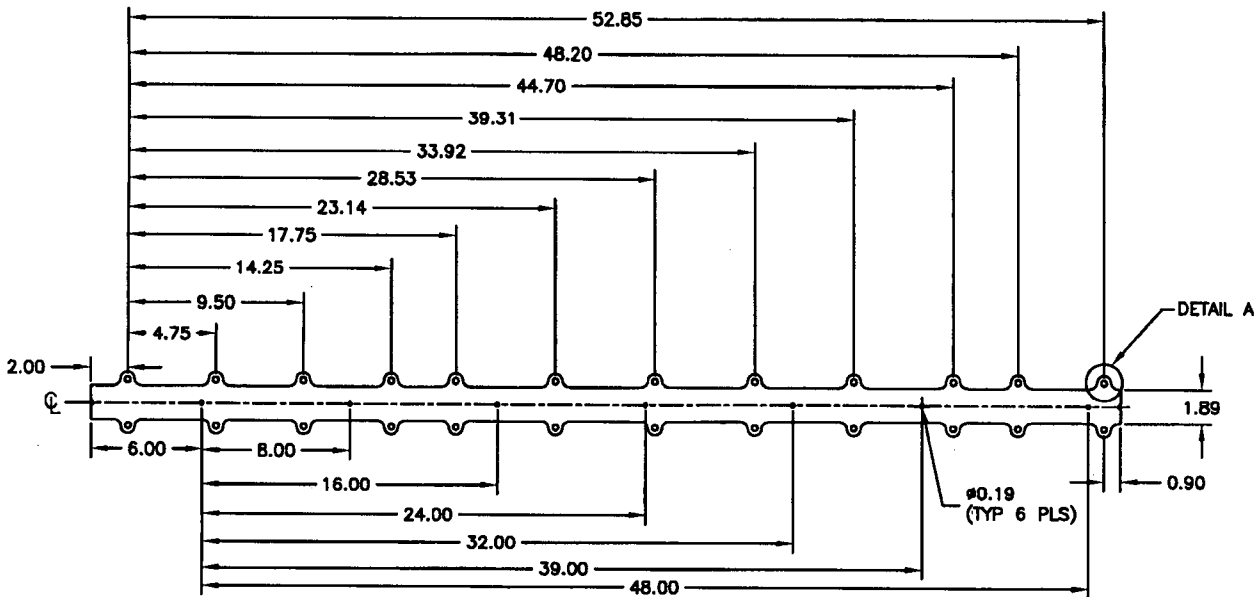
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NOTE: Date & initial all entries

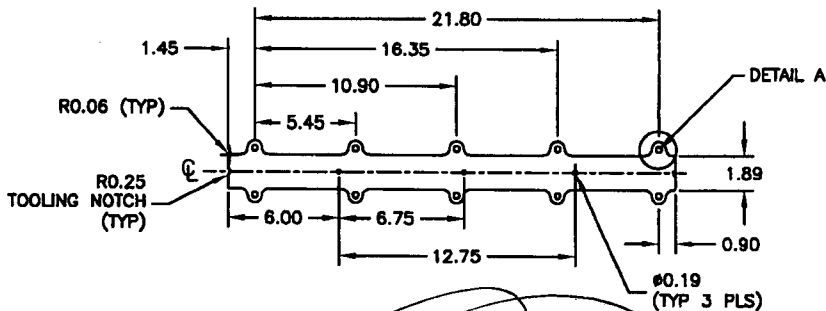
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DATE 06.10.25	TITLE GASKET		SCALE 1:10



D3536-23 GASKET

W/O 61707



D3536-25 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 8 FOR DETAILS AND SECTION

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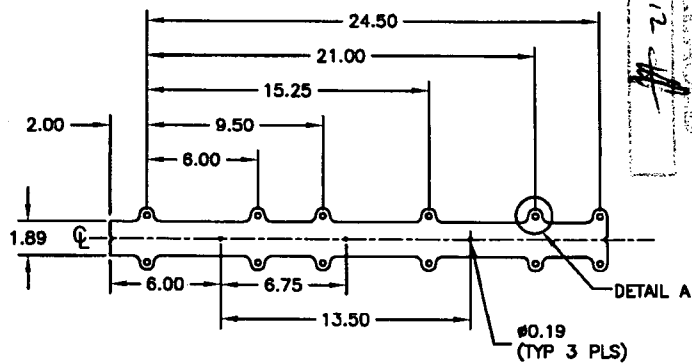
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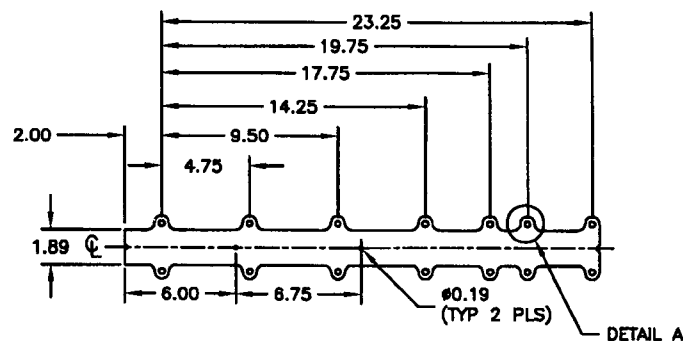
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CHECKED PH	APPROVED PH		SHEET 4 OF 6
DATE 06.10.25	TITLE GASKET	SCALE 1:10	

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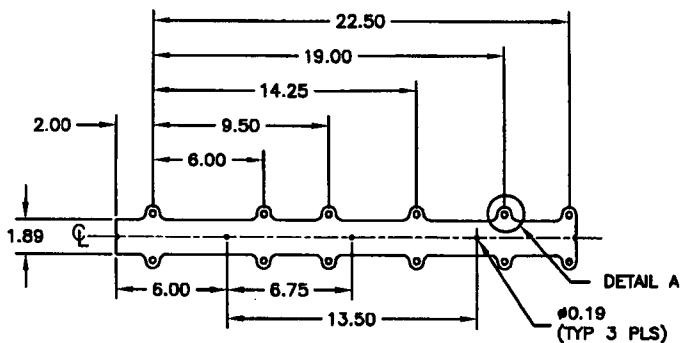


D3536-33 GASKET

w/o 61707



D3536-35 GASKET



D3536-31 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
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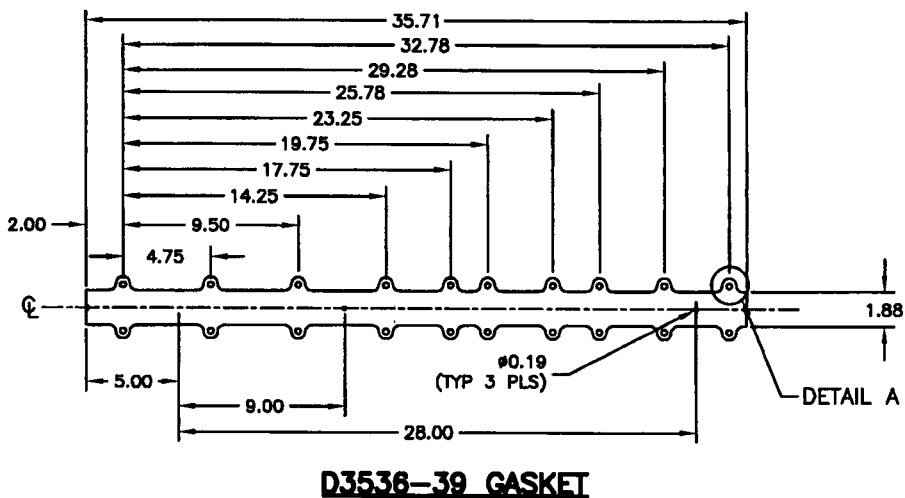
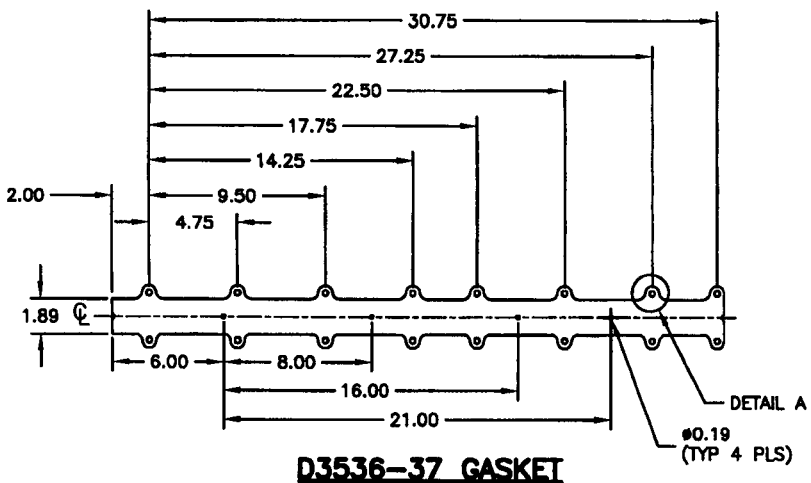
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DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 5 OF 6
				SCALE 1:10

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07.02.12

w/061707



NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO80-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
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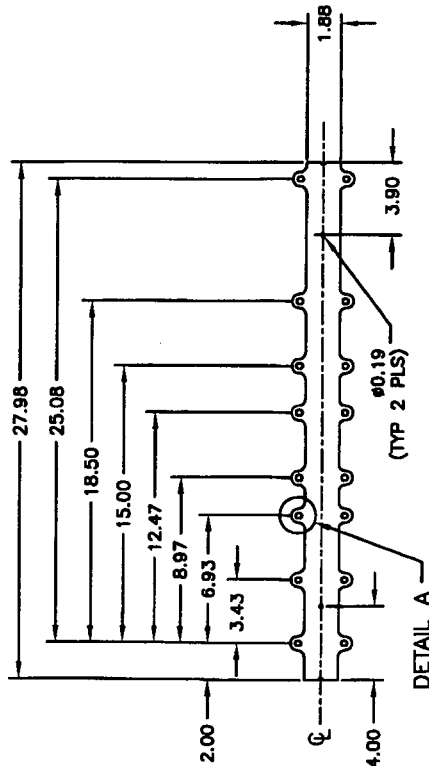
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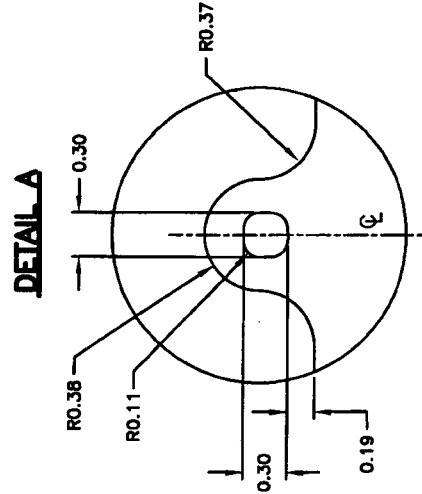
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DATE 06.10.25		TITLE GASKET	SCALE 1:10

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w/o 61707



D3536-41 GASKET



- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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